



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 198715



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/2/19

Job Tracking No: Black sandtex

Due Date: 8/16/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		8/16/19	0.00	0.65	Skidtubes - Bend		MGC
120	Skidtubes - 2 - B4B	1 pcs		8/16/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		TE
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		8/16/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		BE
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S206603



Part: D205-634-041

Job No: 198715

Serial No/Batch: S206603

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3 FAA STC SR005631

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

140 Skidtubes - 3 - B4B	1 pcs	8/16/19	0.00 3.00	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MGa
				Skidtubes - 4 - B4B	BE
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 10	1 pcs	8/16/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	DAS AUG 22 2019 50
				QC 10 - 58	9-89
				QC 10 - 9	
160 QC 5	1 pcs	8/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS AUG 22 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	8/16/19	0.00 1.31	Handfinish - 1 - 1 - B4B	BEB 19-08-23
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 -	

M138410

START: 10:15
O.T. 300
FINISH: 10:45

180 Powdercoat - 1 White Gl(A)-
B4B 1 pcs 8/16/19

190 QC 3 1 pcs 8/16/19

Black Suckler

B4B
Handfinish - 1 - 20 -
B4B
Handfinish - 1 - 21 -
B4B
Handfinish - 1 - 22 -
B4B

Powdercoat - 1 - B4B
Powdercoat - 2 - B4B
Powdercoat - 3 - B4B
Powdercoat - 4 - B4B

BK 17-8-27

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 68

QC 3 - 9

QC 3 - 40

QC 3 - 19

QC 3 - 43

QC 3 - 24

QC 3 - 61

QC 3 - 81

AL 14-8-22

DAS
15
9-89

200 Handfinish - 4-1-Assembly-
B4B 1 pcs 8/16/19

0.00 1.00

Handfinish - 4 - 1 - B4B

Handfinish - 4 - 10 -
B4B

Handfinish - 4 - 11 -
B4B

Handfinish - 4 - 12 -
B4B

Handfinish - 4 - 13 -
B4B

Handfinish - 4 - 14 -
B4B

Handfinish - 4 - 15 -
B4B

Handfinish - 4 - 2 - B4B

Handfinish - 4 - 3 - B4B

Handfinish - 4 - 4 - B4B

Handfinish - 4 - 5 - B4B

Handfinish - 4 - 6 - B4B

Handfinish - 4 - 7 - B4B

Handfinish - 4 - 8 - B4B

Handfinish - 4 - 9 - B4B

M 19-8-27

210 QC 5 1 pcs 8/16/19

0.00 0.00

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
220	Packaging 3-1 - Stock - B4B	1	8/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
225	DC - 1 - B4B	1	8/16/19	0.00 0.00	DC - 1 - B4B	
	pcs				DC - 2 - B4B	
230	QC 21 - FG	1	8/16/19	0.00 0.00	QC 21 - FG - 21	
	pcs				QC 21 - FG - 70	
					QC 21 - FG - 53	

DAS
40
9-09

AUG 29 2019

DAS
19
8-09

AUG 29 2019

AUG 29 2019

Part Op 110 - Skidtubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
Descriptions: batch# in aft end of tube

120 - Skidtubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube

A/R
13901

expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Debur 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 516333 Sikaflex expire date: 19-12-1 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 516333 Sikaflex expire date: 19-12-1 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 514611

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	<u>SP8058</u>
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	<u>5177095</u>
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	<u>5184047</u>
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5196021</u>
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>514958-1</u>
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5192134</u>
D2594-1 <i>Blk smdler</i>	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5206801</u>
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5173297</u>
D2855 <i>Blk smdler</i>	Cap <u>520321</u>	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5173297</u>
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5196347</u>
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5196227</u>
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5201520</u>
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5201653</u>
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5193134</u>
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5178378</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	4	0
140-Skidtubes - 3 - B4B	D2576-3	1	78	0
	D4202-1	20	861	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,256	0
	AN3-5A	2	84	0
	AN3C4A	50	1,293	0
	D2594-1	16	170	0
	D2594-3	16	195	0
	D2855	1	93	0
	D3564-11	1	27	0
	D3564-13	1	16	0
	D3564-5	1	16	0
	D3564-9	1	18	0
	NAS1149C0332R	50	3,504	0
	NAS1149D0332J	2	2,549	0

Part Specifications

Specifications could not be found.

